

Date: Monday, 7/9/2007 11:47:03 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	STEM	
Job Number	33362A				
Estimate Number	10399				
P.O. Number	N/A		Part Number	D29683	
This Issue	7/9/2007	S.O. No.	N/A	Drawing Number	D2968
Prsht Rev.	NC	Type	MACHINED PARTS	Project Number	N/A
First Issue	N/A			Drawing Revision	B/C
Previous Run	32503A			Material	N/A
Written By			Due Date	7/20/2007	Qty: 12 Um: Each
Checked & Approved By	<i>JH</i> 07.07.09				
Comment	Est:C 03.04.11 Reformat; Incorporated D2968-1/5 KJ/RF				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M4130NR0750	4130 steel rod .750"
		Comment: Qty.: 0.3762 f(s)/Unit Total : 4.5146 f(s) Material: AISI 4130 Ø 3/4 " Bar (M4130N-R0.750) Batch: <i>11104452</i> <i>20 07/08/07</i> Identify AS D2968-3
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		Comment: HARDINGE CNC LATHE SMALL 1-Turn Blank as per Folio FA048 and Dwg D2968 2-Deburr, no sharp edges <i>20 07/08/07</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>20 07/08/07</i> (14)
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA048 and Dwg D2968 2- Deburr <i>20 07/09/08</i> (14)
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>20 07/09/08</i> (14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/09/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:47:04 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEM

Job Number: 33362A

Part Number: D29683

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC8 SECOND CHECK



Comment: SECOND CHECK

7/09/10 14

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/09/10 14

8.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/09/10 14

Job Completion



U 7/09/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

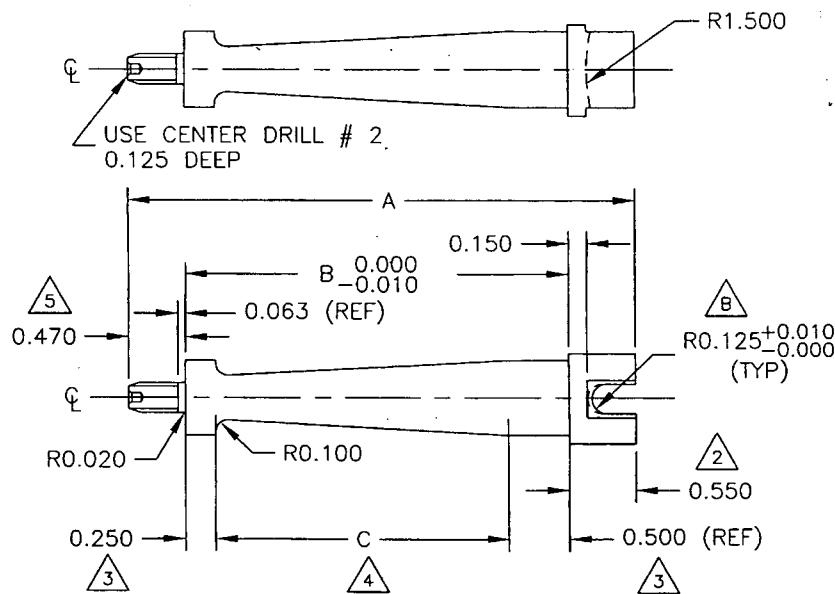
DART AEROSPACE LTD	Work Order:	33362A
Description: Stem	Part Number:	D2968-3
Inspection Dwg: D2968	Rev: B/C PH 07.07.09	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	RQ / 315	Audited by:	N/A
Date:	07/09/08	Date:	07/09/10

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	P/O D2968-043	KJ/RF xx xx



PART NUMBER	A	B	C
D2968-1	5.040	4.020	3.270
D2968-3	4.200	3.180	2.430

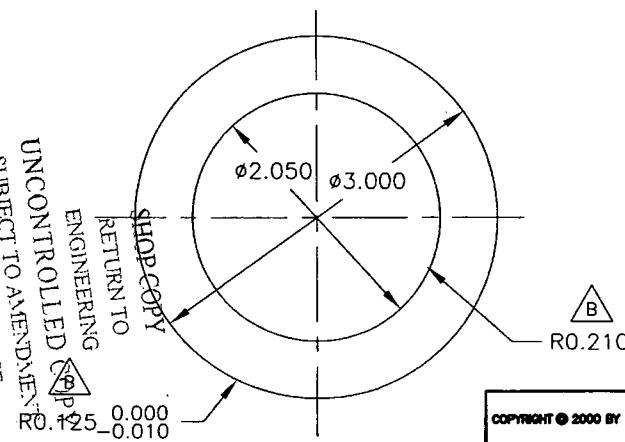
D2968-1/-3 STEM

D2968-1 AND D2968-3 STEM:

- 1) MATERIAL: AISI 4130N ROUND BAR PER MIL-S-6758
OR AMS 6348/6370/6528
(REF DART SPEC M4130N-RX.XXX)
- 2) Ø0.750 O.D.
- 3) Ø0.625 O.D.
- 4) MACHINE UNIFORM TAPER FROM Ø0.363 O.D.
TO Ø0.625 O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
UNLESS OTHERWISE INDICATED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

D2968-5 RING:

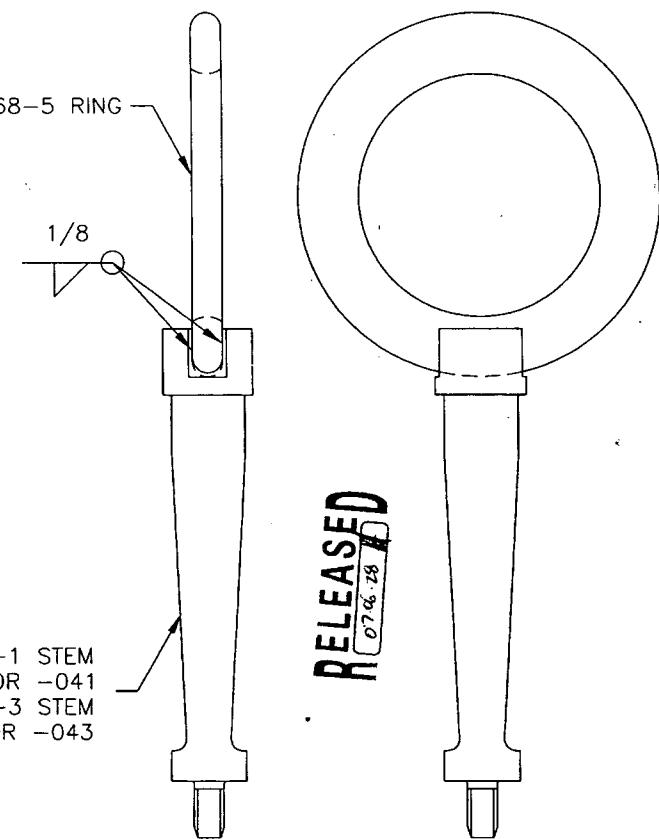
- 9) MATERIAL: AISI 4130N TUBING PER MIL-T-6736
OR AMS 6360/6361/6362/6371/6373/6374
(REF DART SPEC M4130NT3000W500)
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2968-5 RING

COPYRIGHT © 2000 BY DART AEROSPACE LTD.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN	07.04.17	2.050 WAS 2.000, UPDATE NOTES
DRAWN BY	PF	DART AEROSPACE LTD. MARKSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2968 REV. C SHEET 1 OF 1
DATE	07.04.17	TITLE TOW RING SCALE 1:1



RELEASED
07.04.28

L-275
1/25
150

